

Date: Monday, 6/12/2006 2:25:45 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 27485		
Estimate Number	: 10330		
P.O. Number	: N/A	Part Number	: D2746
This Issue	: 6/12/2006 S.O. No. : N/A	Drawing Number	: D2746 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: C
Previous Run	: 25841	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 6/30/2006
Checked & Approved By	: <u>06.06.12</u>	Qty:	30 Um: Each
Comment	Est Rev: 02.10.24 Re-format KJ Est Rev: E 06-03-21 as Per Rev C JLM Est Rev: F 06-06-12 Now On Waterjet JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2746

Dwg Rev: CProg Rev: C

2-Deburr if necessary

06.06.13

(30)

2.0	M1010S20GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.4263 sf(s)/Unit Total : 12.7890 sf(s)

1010/1025/A21/6aA .040" SHEET

(M1010S20GA)

Batch: m100473

06.06.13

(30)

06.06.13

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06.06.13

(30)

4.0	QC8	SECOND CHECK
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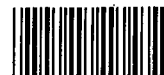


Comment: SECOND CHECK

06.06.13

(30)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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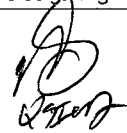
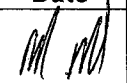
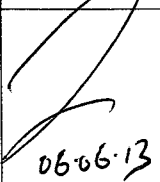
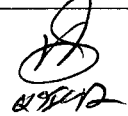
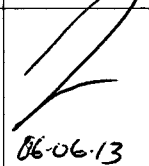
Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

m.f. 06/06/27

(30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-06-13	1.0						

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-06-13	1.0	2 pieces scrap because holes did not cut all the way around (cut and scrap)		cut 2 and replace.	 06-06-13	 06-06-13	 06-06-13	 06-06-13

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/07/10

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/12/2006 2:25:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 27485

Part Number: D2746

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on CNC Brake as per Dwg D2746 using Jigs DT8261 and DT8326

2-Form joggle on Punch as per Dwg D2746 using Jig DT8158 Identify as D2746

SB 06/04/07 (30)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/06/07 30

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FC 06 07 05 (30)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m 06-07-05 (30)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP 20

FC 06 07 05 (30)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/06 (30)

Job Completion



W 06 07 05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

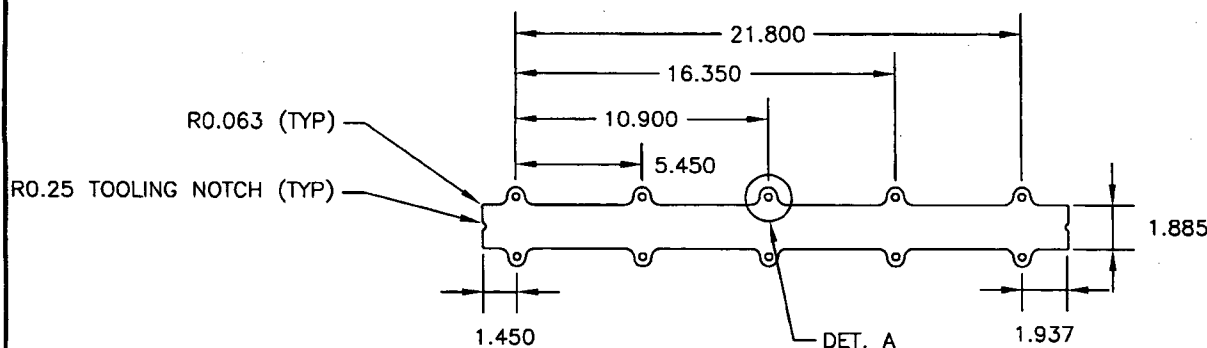
QA: N/C Closed: _____ Date: _____

DART

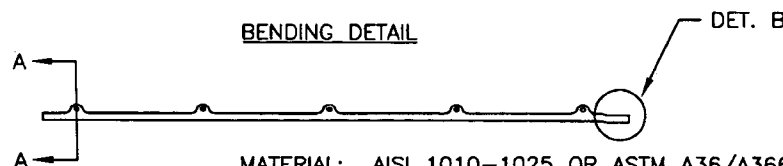
RELEASED
06-01-12

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
F41	F41	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D2746
DATE	TITLE	SHEET 1 OF 1
06.01.12	WEARSHOE	SCALE
		1:8
A	98.04.16	NEW ISSUE
B	98.08.18	RE-DESIGN
C	06.01.12	ENLARGE HOLES TO IMPROVE FIT

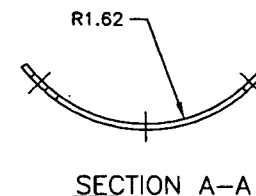
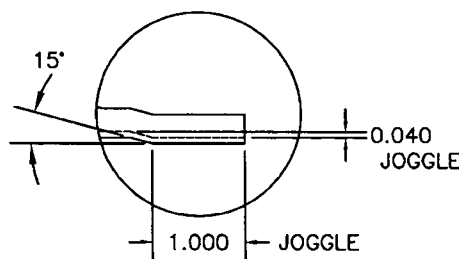
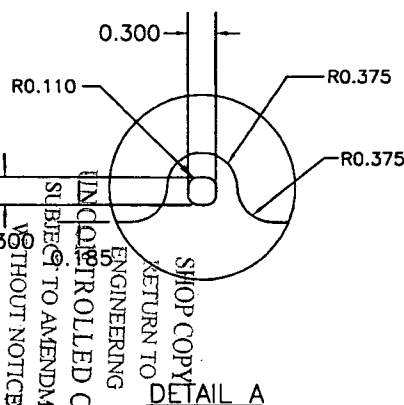
FLAT PATTERN



BENDING DETAIL



MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)



NOTES

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL, 20 GAUGE (0.040 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) THIS PART CAN BE MADE BY MODIFYING D2656-21

